

# Work Order ID 79424

**\*79424\***

Page 1

January-26-12 8:07:55 AM

Item ID: D2573 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Aft Out 205  
 Start Date: 26/01/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 15/02/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/26 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	Rev E								

100 0.00  
**\*100\*** HAAS CNC VERTICAL MACHINING #1  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Program Batch No. 79424 Double check by: RR 1-Machine Step  
 No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine  
 Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-  
 Machine Step No 3 per Folio FA051 and insp

110 0.00  
**\*110\*** CONVENTIONAL MILLING MACHINE  
 Mill Conv Memo 0.00  
 Conventional Milling Machine Machine keyway as per dwg D2573 & D2574

120 0.00  
**\*120\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79424

January-26-12 8:07:55 AM

**\*79424\***

Page 2

Item ID: D2573 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, Aft Out 205  
Start Date: 26/01/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 15/02/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 8-20 OVEN TEMPERATURE:  
FINISH TIME: 8-50

320°F

8-50

M119480

12X4 M-1 12/02/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

January-26-12 8:08:00 AM

Page 1

Work Order ID: 79424

**\*79424\***

Parent Item: D2573

**\*D2573\***

Parent Item Name: Saddle, Aft Out 205

Start Date: 26/01/2012

Required Date: 15/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	22.0000	1	12			
<b>*D6101-007*</b>									<b>**</b>				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT045

22

70680

3

76839

19

29 2.1 27

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	79424
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.503	.503	.503	.503		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.502	.502	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.127	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.229	3.229	3.229		
V	0.230	0.250		.242	.242	.242	.242		
W	0.115	0.135		.126	.126	.126	.126		
X	0.308	0.313		.310	.310	.310	.309		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.367	.367	.367	.367		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.623	.623	.623	.623		
AC	0.053	0.073		.060	.060	.060	.060		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.514	1.514	1.514	1.514		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.004	2.004	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	22
Date:	12.1.30

Audited by:	HA
Date:	12/02/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

372/15.5  
153/18.5  
114/18.5  
124/18.5  
183/20.2  
429/567.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						251/225 123/128.5	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79424
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.438	0.443		.438	.438	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.500	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.257	.252	.257		
S	0.115	0.135		.128	.127	.127	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.226	3.226	3.226	3.228		
V	0.230	0.250		.240	.238	.239	.240		
W	0.115	0.135		.120	.128	.128	.131		
X	0.308	0.313		.311	.311	.309	.308		
Y	0.760	0.765		.763	.763	.762	.763		
Z	0.352	0.372		.364	.365	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.620	.621	.620		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.248		
AE	1.500	1.520		1.511	1.513	1.512	1.5115		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.275	.280	.275	.275		
AH	0.240	0.260		.250	.248	.248	.250		
AI	2.000	2.020		2.000	2.003	2.004	2.0021		
AJ	0.023	0.043				.033	.033		
Accept/Reject									

Measured by:	amf
Date:	12/01/13/

Audited by:	h.a
Date:	12/02/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 79424
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/8"	1/16"	3/16"	1/8"		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.501	.506		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.250	.250		
S	0.115	0.135		.127	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.226	3.226	3.226		
V	0.230	0.250		.238	.237	.238	.238		
W	0.115	0.135		.131	.130	.129	.129		
X	0.308	0.313		.309	.309	.310	.308		
Y	0.760	0.765		.763	.762	.762	.763		
Z	0.352	0.372		.362	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.620	.620	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.247	.246		
AE	1.500	1.520		1.512	1.513	1.513	1.513		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.272	.272	.275	.275		
AH	0.240	0.260		.248	.249	.247	.248		
AI	2.000	2.020		2.002	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	amf
Date:	12/01/31

Audited by:	DA
Date:	12/02/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 79424 M.L.

RELEASED

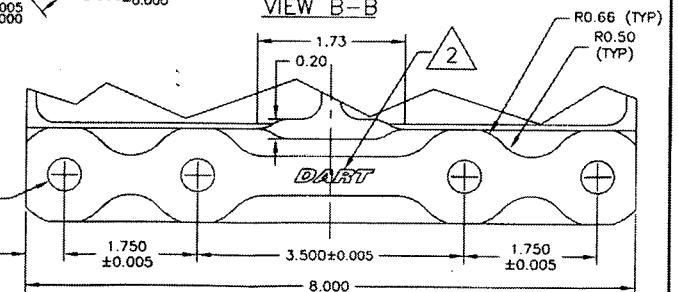
05.12.06

# NOTES

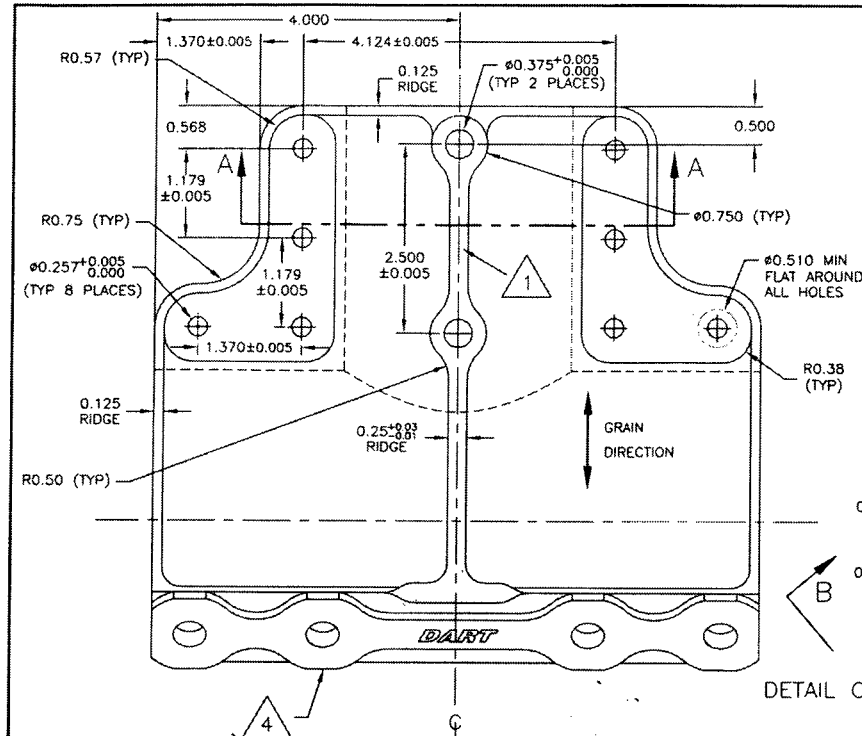
MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

## VIEW B-B



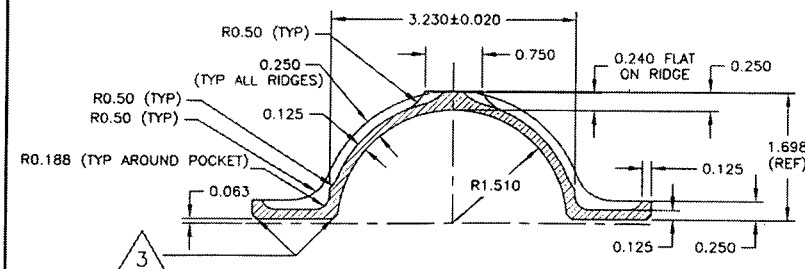
E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE



DETAIL C

SCALE 4:3

DETAIL C  
SCALE 4:3



SECTION A-A

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E	SHEET 1 OF 1
				SCALE	2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries